



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5955
Job Sheet 203128



Part No: D5955

Job Qty: 4 pcs

Part Name: Saddle



Part Weight: 0 lbs

Job Created: 11/11/19

Due Date: 11/25/19

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:F ecn826 06.12.06 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	4 pcs	11/25/19		0.00	0.00	HAAS - 1		WAS 19/11/12
							HAAS - 2	DAS 23 9-89	
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	4 pcs	11/25/19		0.32	11.11	HAAS - 1 - B4B		WAS 19/11/13
							HAAS - 2 - B4B		
							HAAS - 3 - B4B	DAS 23 9-89	
							HAAS - 4 - B4B		
110	QC 2	4 pcs	11/25/19		0.00	0.00	QC 2 - 1		WAS 19/11/13
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Container No: S230953



Part: D5955

Job No: 203128

Serial No/Batch: S230953

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/12/19

120 QC 8	4 pcs	11/25/19	0.00	0.00	QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	-M 19/11/15
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130 Handfinish - 1-1 Chemical-B4B	4 pcs	11/25/19	0.00	0.35	Handfinish - 1 - 1 - B4B	BEB 19-11-18
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 -	

**DAS
40
9-89**

NOV 28 2019

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	4 pcs	11/25/19	0.00 0.00	QC 21 - SA - 21	✓
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21
					57399
					NOV 28 2019

Part Op 100 - (HAAS CNC Vertical Machine), 1-Machine as per folio D5955,Ensure Batch Number is entered
Descriptions: 110 - Inspect on CMM as per folio CMMA018.
120 - (QC8- Inspect parts - second check)
130 - (Chemical Conversion Coat per QSI005 4.1)
140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), START TIME: _____
150 - (QC3- Inspect Part Finish)
160 - (Identify as per dwg & Stock Location:_____)
170 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-013	Saddle Billet	4 pcs (1 ea)	90-Machining - Issue SN	S196174x4
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-013	4	16	0
Part Specifications				
Specifications could not be found.				

Plex 11/11/19 9:18 AM Dart.lajeunesse.marie

DART AEROSPACE LTD

Work Order: 203128

Description: Outer Aft Saddle

Part Number: D5955

Inspection Dwg: D5955

Rev: B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	0.5250	0.5250	5.244		
F	4.745	4.755		4.750	4.750	4.750	4.751		
G	0.315	0.322		0.315	0.315	0.315	0.315		
H	1.522	1.532		1.525	1.525	1.525	1.525		
I	3.048	3.058		3.052	3.052	3.053	3.054		
J	4.575	4.585		4.581	4.581	4.580	4.581		
K	0.315	0.322		0.315	0.315	0.315	0.315		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.502	0.502	0.502	0.502		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		7.996	7.999	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.313	0.312	0.312	0.312		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.504	0.504	0.500	0.502		
T	1.625	1.645		1.625	1.625	1.625	1.625		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DAS

Date: 19/11/12

23

9-89

Audited by:

Date: 19/11/15

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

NCR No.

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date :	Sequence #:	QTY Affected :		MRB (QS042)																													
Description Work Order Deviation		Disposition																															
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY <table><tr><td> Pressure/Forced ☐ </td><td> Contamination ☐ </td><td> Power Loss/Surge ☐ </td><td> Positioned Wrong ☐ </td></tr><tr><td> Bending ☐ </td><td> Misaligned/off center ☐ </td><td> Folio/Program ☐ </td><td> Outside Tolerance ☐ </td></tr><tr><td> Crushing ☐ </td><td> BOM/Route ☐ </td><td> Grain Direction ☐ </td><td> Drawing ☐ </td></tr><tr><td> Cracks ☐ </td><td> Broken/Damage/Defect ☐ </td><td> Weld ☐ </td><td> Finish ☐ </td></tr><tr><td> Crimp/Kink/Ripple/Wave/Twist ☐ </td><td> Incomplete/Unclear Instructions ☐ </td><td> Wrong Stock Pulled ☐ </td><td> Part Lost/Missing ☐ </td></tr><tr><td> Marks/Chatter ☐ </td><td> Drill Holes ☐ </td><td> Out of Sequence ☐ </td><td> Misread ☐ </td></tr><tr><td> Mislabeled ☐ </td><td> Fit/Function ☐ </td><td> Off-set/Set-up ☐ </td><td></td></tr></table> Other/Details:				Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐	
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Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐																															
Completed By																																	
Lead hand / Supervisor																																	
QC / QA Coordinator																																	